

Date: Thursday, 8/24/2006 11:11:37 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEM  
 Job Number : 28332  
 Estimate Number : 11107  
 P.O. Number : N/A Part Number : D34071  
 This Issue : 8/24/2006 S.O. No. : N/A Drawing Number : D3407 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 26516 Material : N/A  
 Due Date : 9/20/2006 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : 06.08.24  
 Comment : Est Rev:A 05.10.18 New issue KJ/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174R0750 Inventory



5.4



Comment: Qty.: 0.3243 f(s)/Unit Total : 4.6116 f(s)  
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)  
 Identify for D3407-3  
 Batch: M100841

J.G 06/09/14 12

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA596 Rev: N/A & Dwg D3407 Rev: C

2-Deburr

J.G 06/09/14 12

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/09/14 12

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

Er 06/09/16 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/09/18

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 8/24/2006 11:11:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 28332

Part Number: D34071

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EN 06/09/16 x17

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/09/16

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST434

CB  
LB 06/09/18 (12)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

12  
06/09/18

Job Completion



u 06.09.18

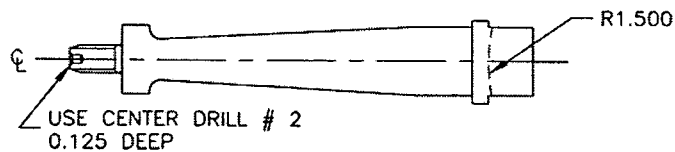
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

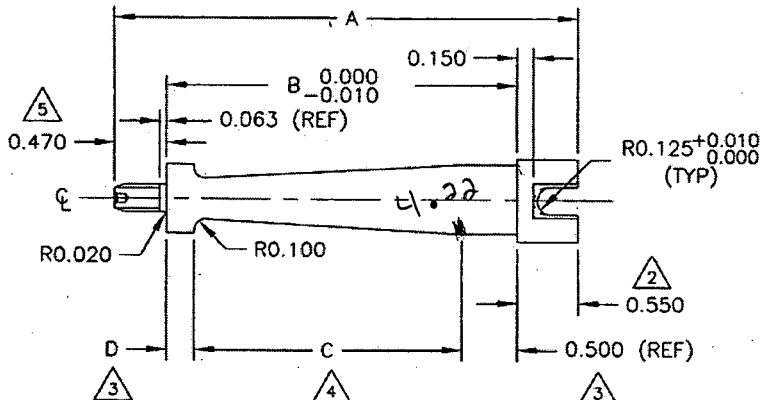
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

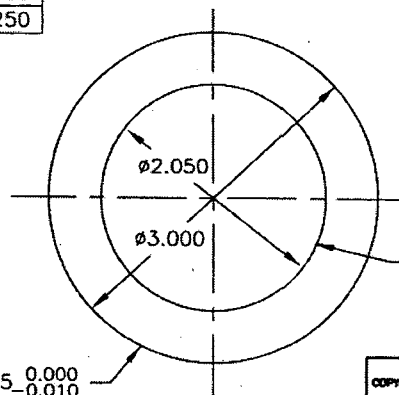
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

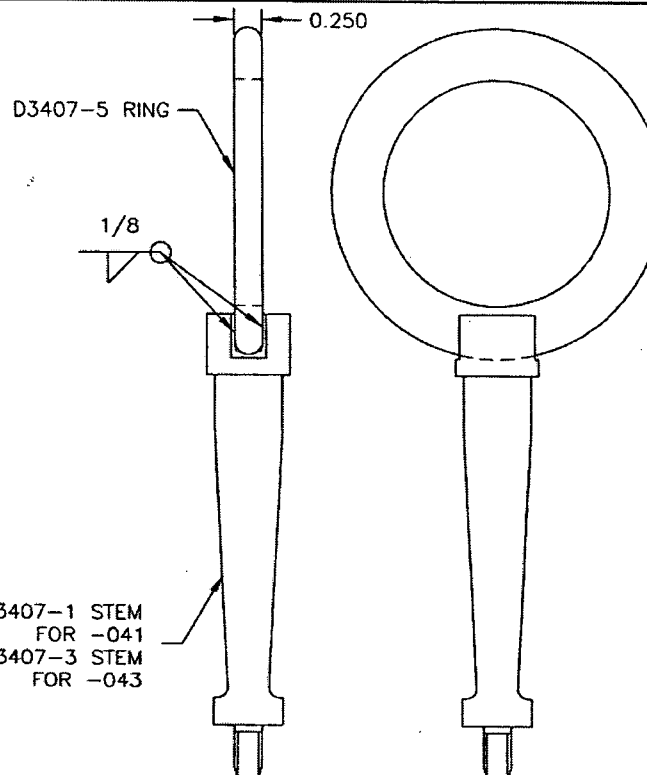
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED #
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 0
DART DART AEROSPACE USA, INC.		SHEET 1 OF 1
PORT HADLOCK, OH		SCALE 1:1

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WORK ORDER  
28332  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28332
<b>Description:</b>	<b>Part Number:</b> D3407-1
<b>Inspection Dwg:</b> 3407-1, Rev: C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.270	$\pm 0.010$	5.272	✓			
4.250	$\pm 0.000$ $-0.010$	4.244	✓			
3.250	$\pm 0.010$	3.250	✓			
0.500	$\pm 0.010$	0.499	✓			
0.500	$\pm 0.010$	0.500	✓			
0.470	$\pm 0.010$	0.470	✓			
0.625	$\pm 0.010$	0.626	✓			
0.750	$\pm 0.010$	0.749	✓			
0.625	$\pm 0.010$	0.624	✓			
0.363	$\pm 0.010$	0.364	✓			
0.063 (RAD)	$\pm 0.010$	0.063	✓			
R0.020	$\pm 0.010$	0.020	✓			
0.550	$\pm 0.010$	0.551	✓			
0.625	$\pm 0.010$	0.627	✓			
0.250	$\pm 0.010$ $-0.000$	0.251	✓			
0.150	$\pm 0.010$	0.151	✓			
MOW	$\pm 0.001$	0.266	✓			
= 0.266						

<b>Measured by:</b> S.G.	<b>Audited by:</b> J.L.	<b>Prototype Approval:</b>
<b>Date:</b> 06/09/16	<b>Date:</b> 06/09/16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	